

Work Order ID 57631

April 12, 2010 11:40:39 AM



Page 1

Item ID: D2574

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Aft In 205

Start Date: 16/04/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 23/04/2010 Req'd Qty: 8.00

Customer:

Reference: *Final 10-04-12*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2574

Rev E

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. *DTP* Double check by: *df* 1-1-Machine Step No
1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step
No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine
Step No 3 per Folio FA051 and insp

MUF
10/04/21 / *DTP*
10/04/22

8

Ø

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2573 & D2574

MUF
10/04/21 / *DTP*
10/04/22

8

Ø

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

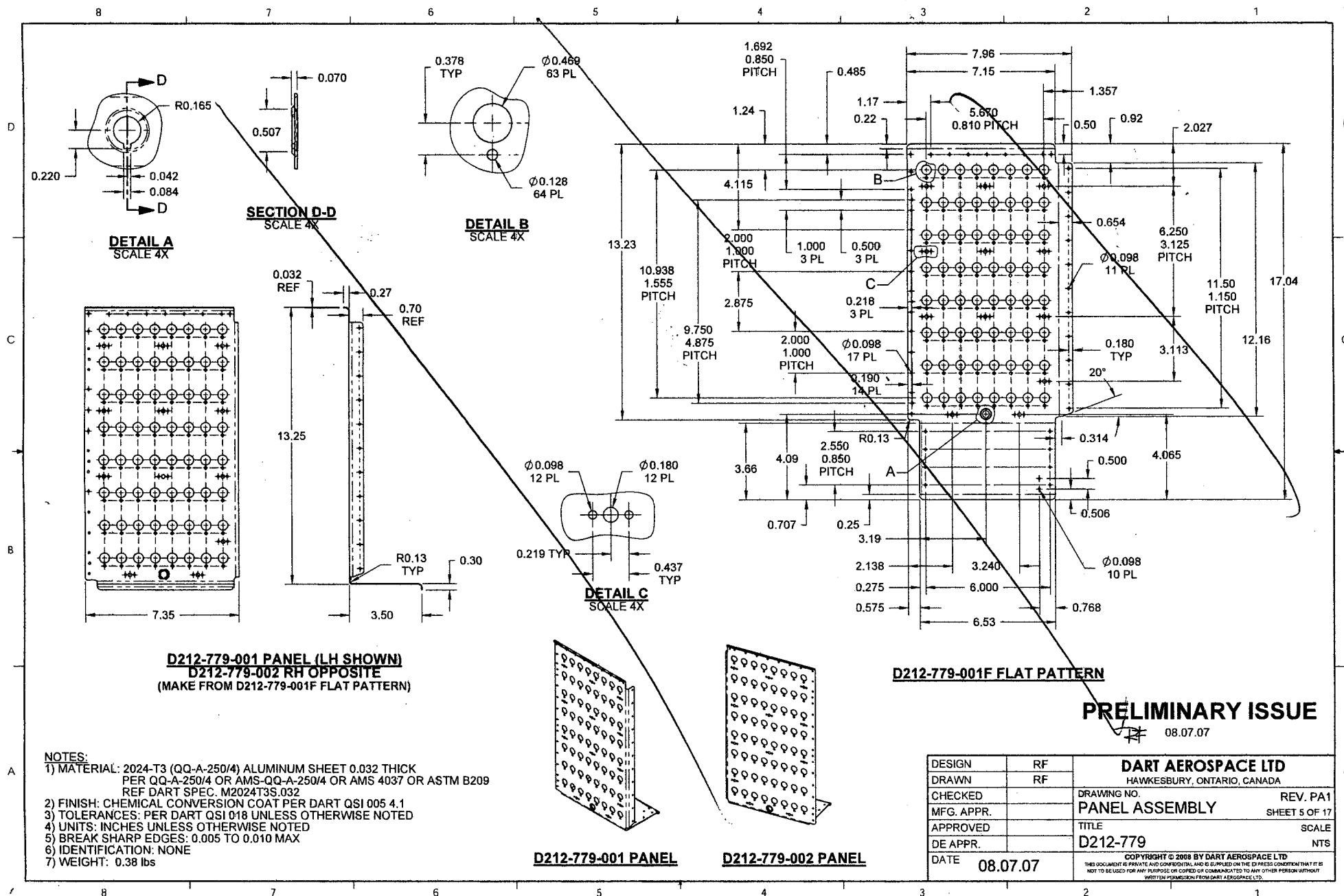
0.00

Quality Control

MUF
10/04/21 / *DTP*
10/04/22

8

Ø



Work Order ID 57631

April 12, 2010 11:40:39 AM



Page 2

Item ID: D2574

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Aft In 205

Start Date: 16/04/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 23/04/2010 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

H.A 10/04/24

8

0

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

8. 10-4-26

HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

111000 10/04/26

28 0

Powdercoat

Memo

0.00

Powder Coating

START TIME:

11:30

FINISH TIME:

11:00

OVEN TEMPERATURE:

320°C

WASHERS. FOR SKIDTUBES AND KITS AT AN EARLIER CHANGE NUMBER, IT IS ACCEPTABLE TO REPLACE NAS1515H8L WASHERS WITH D3672-13 WASHERS. THE PARTS LIST OF INSTALLATION INSTRUCTIONS IIN-D350-636 REV. F IS AMENDED AS FOLLOWS:

ITEM	QTY -011	QTY -012	QTY -013	QTY -014	QTY -103	QTY -104	PART NUMBER	DESCRIPTION
	X						D350-636-011	SKIDTUBE INSTALLATION, LH
		X					D350-636-012	SKIDTUBE INSTALLATION, RH
			X				D350-636-013	SKIDTUBE INSTALLATION, LH
				X			D350-636-014	SKIDTUBE INSTALLATION, RH
					X		D350-636-103	APICAL FLOAT INSTALLATION KIT, LH
						X	D350-636-104	APICAL FLOAT INSTALLATION KIT, RH

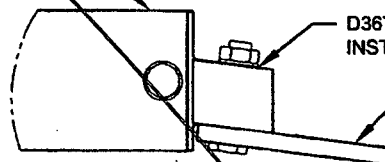
IS:

11B	2	2	2	2	2	2	D3672-13	WASHER
-----	---	---	---	---	---	---	----------	--------

WAS:

11B	2	2	2	2	2	2	NAS1515H8L	WASHER
-----	---	---	---	---	---	---	------------	--------

AFT END OF SKIDTUBE, REF



LOCATION OF WASHER
(DETAIL D OF IIN-D350-636)

A	NEW ISSUE, PAR 09-038	CP	09.11.04
REV.	DESCRIPTION	BY	DATE
DESIGN	qp	DART AEROSPACE USA, INC	
DRAWN	qp	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9490	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		WASHER CHANGE	NTS
DATE	09.11.04	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Work Order ID 57631

April 12, 2010 11:40:39 AM

Page 3

Item ID: D2574

Accept

Revision ID:

Item Name: Saddle, Aft In 205

Start Date: 16/04/2010 Start Qty: 8.00

Required Date: 23/04/2010 Req'd Qty: 8.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

(8)

10-4-26

170

Identify as per dwg & Stock Location: 434

0.00



Packaging

Packaging

Memo

0.00

10-4-26 (8x) SP

180

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

10/04/27

MF 10-4-26

6.0 PARTS LIST

(D350-636-011/-012/-013/-014 SKIDTUBES AT CHANGE 004 OR LATER)

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -045	Part Number	Description
	X					D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
		X				D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
			X			D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRAUSER/ APICAL TRI-BAG FLOAT COMPATIBLE
				X		D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRAUSER/ APICAL TRI-BAG FLOAT COMPATIBLE
					X	D350-636-045	WEARSHOE KIT
1	1					D2750-041	SKIDTUBE ASSEMBLY, LH
1		1				D2750-042	SKIDTUBE ASSEMBLY, RH
1			1			D2750-043	SKIDTUBE ASSEMBLY, LH
1				1		D2750-044	SKIDTUBE ASSEMBLY, RH
*1	1					D2750-1	SKIDTUBE WELDMENT, LH
*1		1				D2750-2	SKIDTUBE WELDMENT, RH
*1			1			D2750-3	SKIDTUBE WELDMENT, LH
*1				1		D2750-4	SKIDTUBE WELDMENT, RH
**2	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8		22541N120	NUT
*5	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1		AN960C816L	WASHER
*7	1	1	1	1		MS21083C8	NUT
*8	1		1			D3488-041	BLADE FITTING, LH
*8		1		1		D3488-042	BLADE FITTING, RH
9	1	1	1	1		D2741	BLADE
10	2	2	2	2		AN8C21A	BOLT
11A	2	2	2	2		AN960C816L	WASHER
11B	2	2	2	2		NAS1515H8L	WASHER
12	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8		D2745	BUSHING
*16	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4		AN960C10L	WASHER
*20B	4	4	4	4		NAS1515H3L	WASHER

(CONTINUED ON NEXT PAGE)

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Revision: F

Date: 08.08.14

Picklist Print

April 12, 2010 11:40:38 AM

Page 1
1

Work Order ID: 57631



Parent Item: D2574



Parent Item Name: Saddle, Aft In 205

Start Date: 16/04/2010

Required Date: 23/04/2010

Comments: IPP Rev: I As Per RevE 06-01-27 JLM

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-005		Manufactured	No			110	Each	86.0000	8.0000			



Saddle Billet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT46

86

46411

86

8 STP 10/04/22

(CONTINUED FROM PREVIOUS PAGE)

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -045	Part Number	Description
*22	3	3	3	3	3	D3537-1	WEARPAD
*22A	1	1	1	1	1	D3791-1	WEARPLATE (REPLACES D3537-1)
*23A	1	1	1	1	1	D3793-1	WEARSHOE (REPLACES D3535-13)
*23B	1	1	1	1	1	D3794-1	GASKET (REPLACES D3536-13)
*24A	1	1	1	1	1	D3535-25	WEARSHOE
*24B	1	1	1	1	1	D3536-25	GASKET
*25A	1	1	1	1	1	D3793-3	WEARSHOE (REPLACES D3535-35)
*25B	1	1	1	1	1	D3794-3	GASKET (REPLACES D3536-35)
*26A	34	34	34	34	34	AN3C5A	BOLT
*27	34	34	34	34	34	AN960C10L	WASHER
*28	34	34	34	34		ALS41032-225	INSERT
*30	8	8	8	8		D3492-041	PLUG ASSEMBLY
*31	8	8				D3492-043	PLUG ASSEMBLY
*32			8	8		D3492-045	PLUG ASSEMBLY
***43	2	2	2	2		D3493-1	WASHER
50	2	2				D3532-1	SPACER

* PART OF D2750-041/-042 OR D2750-043/-044 ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING AN APICAL FLOAT SYSTEM

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Revision: F

Date: 08.08.14

DART AEROSPACE LTD	Work Order:	57631
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	0.441		
B	1.745	1.755		1.747	1.747	1.750	1.750		
C	3.495	3.505		3.497	3.500	3.500	3.500		
D	1.745	1.755		1.747	1.747	1.750	1.750		
E	7.990	8.010		8.005	8.001	8.004	8.004		
F	0.490	0.510		.492	.505	0.499	0.502		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.499	.500	.503		
J	1.174	1.184		1.177	1.178	1.178	1.178		
K	0.558	0.578		.570	.566	.566	.570		
L	1.174	1.184		1.177	1.178	1.178	1.178		
M	1.365	1.375		1.369	1.369	1.369	1.369		
N	2.495	2.505		2.497	2.498	2.498	2.499		
O	4.119	4.129		4.122	4.122	4.122	4.122		
P	0.115	0.135		.126	.122	.123	.124		
Q	0.115	0.135		.125	.135	.135	.135		
R	0.240	0.260		.250	.254	.250	.253		
S	0.115	0.135		.130	.135	.130	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.228	3.230	3.228		
V	0.230	0.250		.235	.242	.238	.237		
W	0.115	0.135		.126	.130	0.129	0.130		
X	0.307	0.312		.310	.310	0.311	0.311		
Y	0.760	0.765		.762	.763	0.764	0.764		
Z	0.352	0.372		.365	.365	0.368	0.368		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.625	0.626	0.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.513	1.510	1.510	1.510		
AF	0.115	0.135		.135	.135	0.135	0.135		
AG	0.240	0.280		.265	.275	.275	.275		
AH	0.240	0.260		.250	.253	.251	.246		
AI	2.000	2.020		2.003	2.001	2.001	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>mm</i>
Date: <i>10/04/24</i>

Audited by: <i>h.a</i>
Date: <i>10/04/24</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

PROGRAM MODIFICATION FOR PART NUMBERS

PART NUMBER: _____			
Program Number	NCC File	Tool Number	Mod. to be Preformed & Operation Description (Specify Line #)

Requested By: _____ Done By: _____

DART AEROSPACE LTD		Work Order: 5763/
Description: Saddle, Aft Inboard		Part Number: D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	26	27	28		
A	0.438	0.443		0.441	0.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.004	8.006	8.006		
F	0.490	0.510		0.503	.501	.503	.503		
G	0.257	0.262		.260	.260	.260	0.260		
H	0.375	0.380		.377	.377	.378	0.378		
I	0.490	0.510		0.502	0.501	0.503	0.503		
J	1.174	1.184		1.179	1.178	1.179	1.179		
K	0.558	0.578		0.570	0.569	0.571	0.571		
L	1.174	1.184		1.179	1.178	1.179	1.179		
M	1.365	1.375		1.369	1.370	1.370	1.370		
N	2.495	2.505		2.498	2.499	2.500	2.500		
O	4.119	4.129		4.122	4.122	4.124	4.124		
P	0.115	0.135		.125	.123	0.124	0.124		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.252	0.252	0.256	0.252		
S	0.115	0.135		0.132	0.131	0.132	0.132		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.228	3.230	3.230		
V	0.230	0.250		0.237	0.237	0.237	.238		
W	0.115	0.135		0.128	.128	.130	.130		
X	0.307	0.312		0.3105	.310	.310	.310		
Y	0.760	0.765		0.764	.762	.763	.762		
Z	0.352	0.372		0.369	.370	.368	.369		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	.626	.629	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.509	1.512	1.513	1.513		
AF	0.115	0.135		0.135	.135	.135	.135		
AG	0.240	0.280		0.250	.250	.250	.250		
AH	0.240	0.260		0.248	0.247	0.247	0.247		
AI	2.000	2.020		2.000	2.003	2.004	2.004		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>mf</i>	Audited by: <i>A.A</i>
Date: 10/04/24	Date: 10/04/22

Measured by: <i>mf</i>	Audited by: <i>A.A</i>
Date: 10/04/24	Date: 10/04/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

PROGRAM MODIFICATION FOR PART NUMBERS

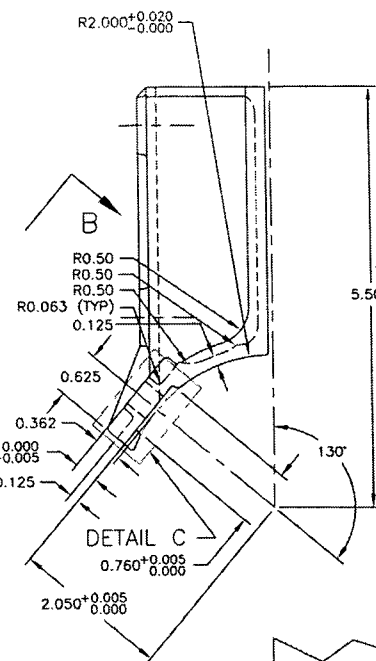
PART NUMBER: _____			
Program Number	NCC File	Tool Number	Mod. to be Preformed & Operation Description (Specify Line #)

Requested By: _____





Done By: _____

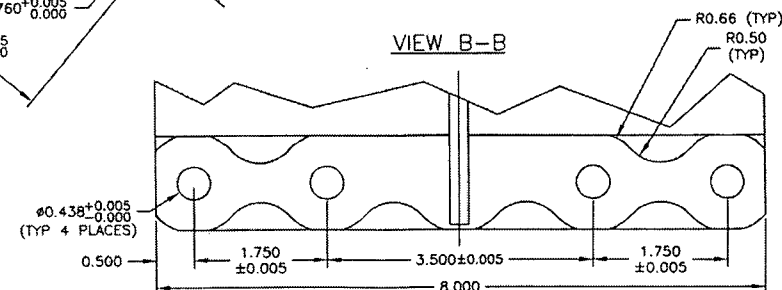
RELEASED

OK, 2.0



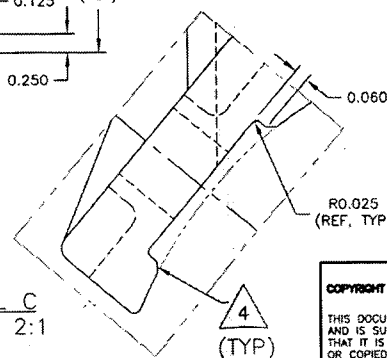
MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|-------------------------------------------------------------------------------------|------------------------------------------------------------------|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063 x 45° ALL AROUND |
|  | CHAMFER 0.033 x 45° (SEE DETAIL C) |



SECTION A-A




VIEW B-B



DETAIL C
SCALE 2:1

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E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCRP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN DS		 DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
DRAWN BY PH		
CHECKED 	APPROVED 	DRAWING NO. D2574
DATE 05.07.13		TITLE INNER AFT SADDLE
		REV. SHEET 1 OF 2